






# Work Order ID 53601



November 9, 2009 1:42:37 PM



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Item ID: D3159-043 Accept  Setup Start   
Revision ID: C Stop   
Item Name: Bracket Assembly  
Start Date: 09/11/2009 Start Qty: 10.00  Cust Item ID:  
Required Date: 20/11/2009 Req'd Qty: 10.00  Customer:  
Reference:

Approvals: Process Plan: BS Date: 09-11-9 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start   
Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3159	Rev C

100  Waterjet HAAS CNC VERTICAL MACHINING #1 0.00

Waterjet Memo 0.00 HB 9-11-11

FLOW CNC Waterjet CUT AS PER FILE D3159-3/-4  
DWG REV: E  
PROG REV: E

DEBURR

110 QC2- Inspect parts off machine FAI/FAIB 0.00

QC Memo 0.00 HB 9-11-11

Quality Control

09/11/13  
HB 9-11-11  
35

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**Accept**

**Setup Start**

**Stop**

**Cust Item ID:**

**Customer:**

**Reference:**

Run Start



**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

35  
\_\_\_\_\_

105/1112

0.00



0.00

1-Deburr break all sharp edges .005 to 0.010 2-C'sink holes as per Dwg D3159

4509/11/17 (35)

0.00



0.00

1-Form as per drawing (Note: -044 OPPOSITE)

SB 09/11/17

25 40

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Item ID: D3159-043	Accept		Setup	Start	
Revision ID: C				Stop	
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Start Date: 09/11/2009	Start Qty: 10.00		Cust Item ID:		
Required Date: 20/11/2009	Req'd Qty: 10.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00	⇒ 09/11/19			35	Ø		
160  Small Fab Small Fab	Small Fab  Memo Assemble as per dwg.	0.00 0.00				09/11/23 (35)			
170  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	⇒ 807/11/25						

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Item ID: D3159-043

Accept



Setup Start



Revision ID: C

Stop



Item Name: Bracket Assembly

Start Date: 09/11/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Identify as per dwg & Stock Location: <i>sf</i>	0.00							
Packaging Packaging	Memo	0.00							<i>PC 9/11/26 (35)</i>
190 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							<i>09/11/26 (35)</i> <i>PC 09-11-26 (35)</i>

# Picklist Print

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Work Order ID: 53601

Parent Item: D3159-043RevC

Parent Item Name: Bracket Assembly

Comments:

Start Date: 09/11/2009

Required Date: 20/11/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MS20426AD3-13 Purchased No

No

100

Each

7,861.000

20.0000



RIVET

M7681

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

7861

104374

3861

110398

4000

M6061T6S.063 Purchased No

No

160

sf

216.0499

30.4674



6061-T6 .063 Sheet

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT

216.0499211

110551

32.0341211

112939

184.0158

MS21061L06 Purchased No

No

160

Each

129.0000

10.0000



Nutplate

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

129

19085

29

19185

100

9/09/11/23

2

13 9-11-11

(35)

112939

9/09/11/23

14  
21



**DART**

SHOP COPY

RETURN TO

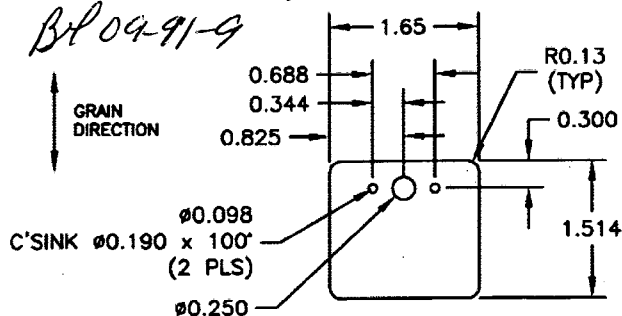
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UNCONTROLLED COPY

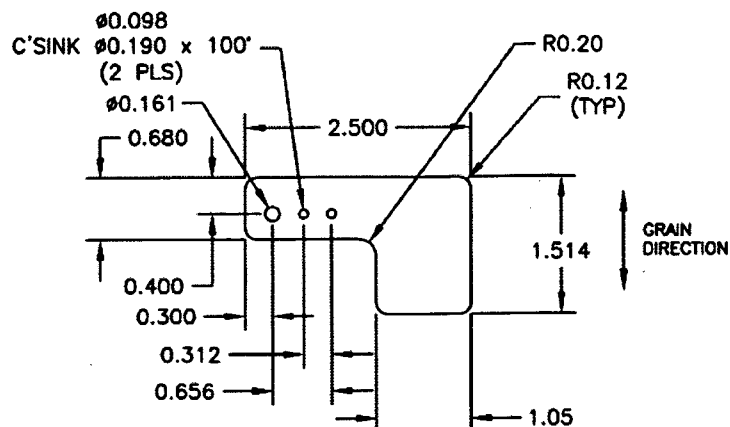
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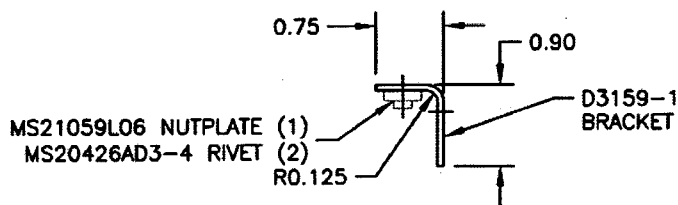
WORK ORDER

NO. 53001BPO491-9

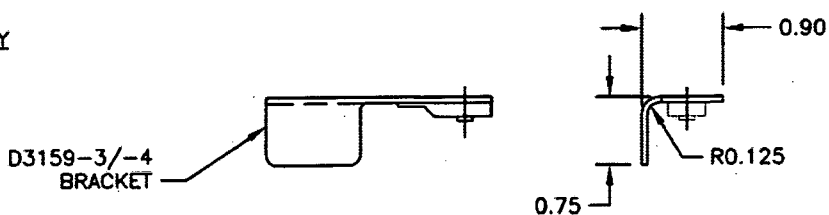
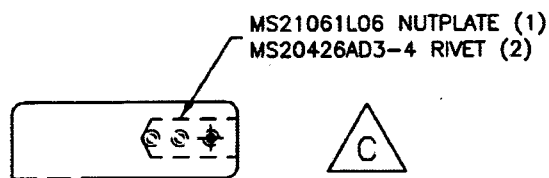
**D3159-1F FLAT PATTERN**  
(USED TO MAKE D3159-1 BRACKET)



**D3159-3F FLAT PATTERN**  
(USED TO MAKE D3159-3/-4 BRACKETS)



**D3159-041 BRACKET ASSEMBLY**

**RELEASED**  
05.12.01

**D3159-043 BRACKET ASSEMBLY (SHOWN).**  
REPLACES PREMIER P/N B30-23000-259  
(D3159-044 BRACKET ASSEMBLY (OPPOSITE).  
REPLACES PREMIER P/N B30-23000-260)

**NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY D3159-041/-043/-044 WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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